



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

copy

RBT18700-101
Job Sheet 192701



Part No: RBT18700-101

Job Qty: 2 pcs

Part Name: Engine Stand



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/29/19

Job Tracking No:

Due Date: 6/18/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBT18700-101 Rev. 7 IPP Rev. A 18.04.17 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	2 pcs	6/18/19	6/18/19	0.00	0.00	Purchasing - 1	JUN 17 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2 - 1 - Receive - B4B	2 pcs	6/18/19	6/18/19	0.00	0.00	Packaging 2 - 1 - B4B	JUN 17 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Container No: S191149



Part: RBT18700 - 101

Job No: 192701

Serial No/Batch: S191149

Revision: 7

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/17/19

Plex 6/17/19 3:25 PM dart.lussier.patrick

				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	DAS
120 QC 6	2 pcs	7/15/19	0.00 0.00	QC 6 - 68	40
				QC 6 - 61	9-89
				QC 6 - 40	
125 Small Fab - 2 - B4B	2 pcs	7/15/19	0.00 0.00	Small Fab - 2 - B4B	BDAS
126 QC 5	2 pcs	7/15/19	0.00 0.00	QC 5 - 40	40
130 Packaging 3-1 - Stock - B4B	2 pcs	7/15/19	0.00 0.00	Packaging 3 - 1 - B4B	JUN 24 2019 99-89
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
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				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	7/15/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 100 - (Purchasing) Issue P/O: 43085 MANUFACTURE RBT18700-101 AS PER DWG Supplier: METEC Certificate
 Descriptions: of conformity is required
 110 - (Receive & Inspect for Damage & Mat'l Certs)
 120 - (QC6- All purchased or subcontracted products)
 125 - 1-Engrave placard as per drawing. 2-Transfer drill placard and install using #2 drive screws.
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	6/18/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
130 Packaging 3-1 - Stock - B4B	2 pcs	6/18/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
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					Packaging 3 - 12 - B4B	
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					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	6/18/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

JUN 21 2019
DAS 40 9-89

JUN 25 2019
DAS 70 9-89

Part Op 100 - (Purchasing) Issue P/O: 043085 MANUFACTURE RBT18700-101 AS PER DWG Supplier: METEC Certificate
Descriptions: of conformity is required

- 110 - (Receive & Inspect for Damage & Mat'l Certs)
- 120 - (QC6- All purchased or subcontracted products)
- 130 - (Identify as per dwg & Stock Location: _____)
- 140 - (QC21- Final Inspection - Work Order Release)

x 2 pln

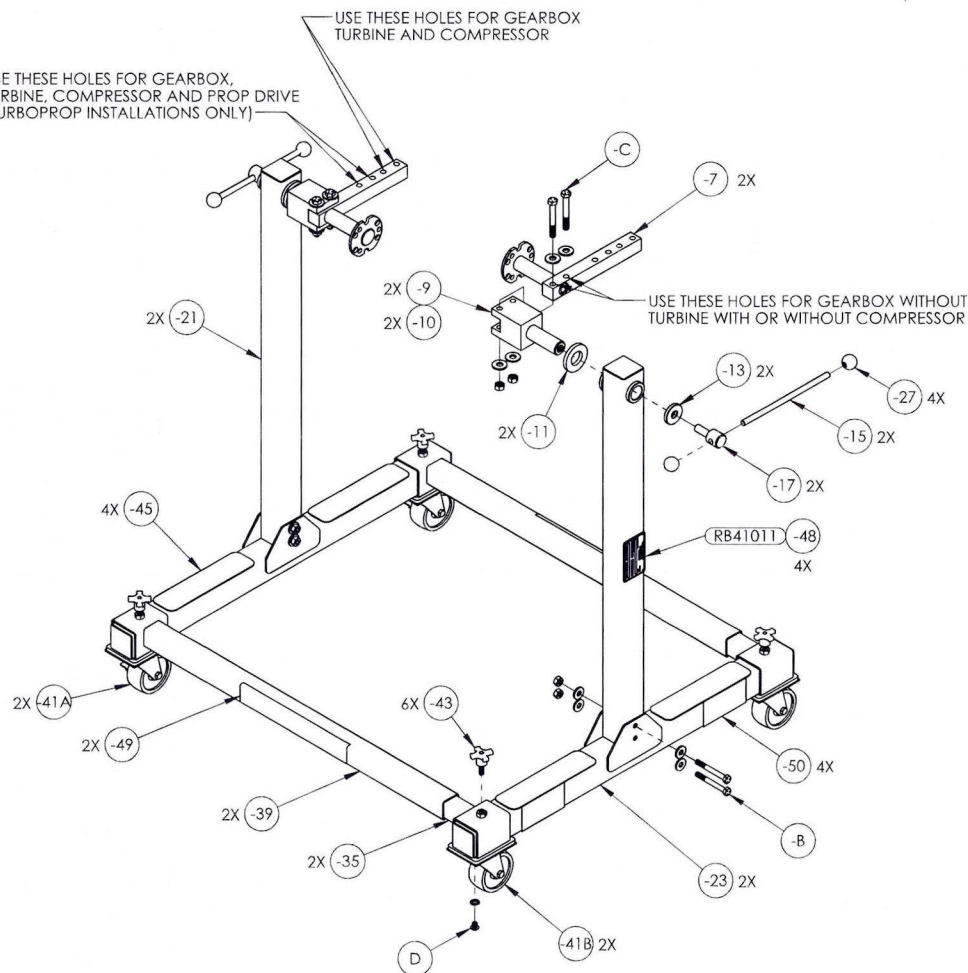
Part / Item	Component Name	Quantity	Operation	Container
RBT18700-101P	Engine Stand	2 pcs (1 ea)	100-Purchasing	
90081A077	Drive Screw #2 1/4" Long	8 Ea (4 ea)	125-Small Fab - 2 - B4B	5140008
RB41011	Dart Tooling Placard, Aluminum	2 pcs (1 ea)	125-Small Fab - 2 - B4B	5021040
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBT18700-101P	2	0	0
125-Small Fab - 2 - B4B	90081A077	8	70	0
	RB41011	2	286	0
Part Specifications				
Specifications could not be found.				

Plex 6/24/19 8:41 AM dart.paquette.daniel

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBT18700-101P	Engine Stand	2 pcs (1 ea)	100-Purchasing	5191147
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBT18700-101P	2	0	0
Part Specifications				
Specifications could not be found.				

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USE THESE HOLES FOR GEARBOX,
TURBINE, COMPRESSOR AND PROP DRIVE
(TURBOPROP INSTALLATIONS ONLY) —



			REVISIONS		DATE	INITIAL	APPROVED
REV	ECR		DESCRIPTION				
1			CREATED R181790-101 RETAINING ALL ORIGINAL R181790-700 DRAWINGS WITH NEW ADDITIONS/ WELDED END CAPS, AND ALL KNOBS MATL.		4/28/2009	WP	RW
2			ADDED REFLECTIVE TAPE, TEST CERT ENBLEM, PLACARD, AND RS EMBLEM.		4/28/2009	WP	RW
2A			ADDED MCMASTER-CARR P/N'S FOR BUY/OUTS IN THE BOM. CHD NOTES $\triangle$ & $\triangle$ -7, -13, -15, -17 CHD FINISH FROM BLACK OXIDE.		8/23/2011	RJC	RW
			-15 CHD THREAD CALL OUT FROM 3/8-1/4 UNC & ADDED NOTE, -17 CHD HOLE DIAMETER FROM 0.377 ± 0.010 , -19 CHD DIM FROM 0.0140 ± 0.005 , -20 CHD TUNG COATING FROM DRILL SEAL UNIVER AND INSTALL FLANGED RINGS FROM SEAM SIDE OF SQUARE THROU & SHOWED SEAM ON UPPER VIEW. -23 CHD WELD CALCULUS.		3/8/2012	RJC	GE
4			-21 REMOVED BOTTOM TUBE CAP.		3/8/2012	RJC	GE
	14-0141		-7 ADDED DIA. (4.595) -10 ADDED R/2, -15 ADDED TOLERANCE TO .375 DIM -17 ADDED $03 \times 45^\circ$ CHAMFER, ADDED TOLERANCE TO 0.385 DIM, DELETED 0.500 ± 0.005 DIM, -20 ADDED TOLERANCE TO 0.1500 DIM, ADDED $\triangle$, $\triangle$ CHD DESCRIPTION WAS BASE ASSEMBLY BASE BASE WELDMENT -27 ADDED DWG FOR ANGLE -29 CHD DIM WAS $25 \pm .025$ -31 CHD DIM WAS $21/64$ HOLE IS 0.33 , DELETED DIM $2X .90$ -33 CHD DESCRIPTION WAS S_1 SLIDE TUBE IS SLIDE TUBE, -35 CHD DIMS WAS $1.146 \pm .014$, $1.145 \pm .010$ (10.00) -37 CHD DESCRIPTION WAS SHORT TUBE TELESCOPING IS LONG TUBE -43 ADDED DRAWING -44 ADDED WITH SUB REMARKS: 1. D.		9/2/2014	DJN	RJC
	15-0214		1. -13, -13 -15 MATERIAL WAS 1018 IS 1018/1020 -4 CHD DIM WAS 0.750 ± 0.002 , -200 S.F. $3 \pm 0.750 \pm 0.002$, -200 88×90 S.F. 3 ± 0.750 -29 CHD DIM WAS $41/64$ Q&T IS $41/64$ Q&T $41/64$ Q&T, -20 ADDED TOLERANCE TO 0.1500 DIM, -23 EXTENDED WELDS AROUND CORNERS OF -25, -25 CHD MATERIAL WAS STEEL SHR P&O DIM WAS $23 \pm .025$ CHD MATERIAL WAS STEEL SHR P&O -31 CHD TO SHEET METAL TOLERANCES -33 ADDED NOTE.		8/28/2015	RJC	JAG
	16-0191		-1, -3, -5, -13, -15 CHD MATL WAS 1018/1020 IS 1018/1020 CR -4 ADDED MACHINED FACE NOTE, DELETED DIM -188, ADDED DIMS .187, (3.008) -5 CHD DIM WAS 0.750 ± 0.002 , THRU ALL $\sqrt{0.88 \times 90^\circ}$, NEAR SIDE $\sqrt{0.35 \pm 0.010} \pm 0.002$, -6 $\sqrt{0.88 \times 90^\circ}$ BOTH SIDES $\sqrt{0.31 - .37}$, -13, -15 -17 ADDED FINISH SPEC, ASTM A483 TYPE 1 R/2, -19 CHD DIMS WAS 1.000 ± 0.005 , -200 S.F. $3 \pm 0.750 \pm 0.002$, -201 S.F. WAS $3.01 \pm .015$ 25×60 10 HELICLOS, IS TAP FOR 1/2-13 HELICLOS, INSERT IS $1/5014$ -17 CHD MATL WAS $11/64 \pm 0.015$ IS 4140/42 ADDED CHD DESCRIPTION WAS HEAT TREAT RC 28-34, -20, -22, -37 CHD MATL WAS 1018/1020 IS 1018/1020 CR -29 CHD DIM WAS 1.000 ± 0.005 , -31 CHD DIM WAS 1.000 ± 0.005 , -33 CHD DIM WAS 1.000 ± 0.005 , -35 CHD DIM WAS 1.000 ± 0.005 , -37 CHD DIM WAS 1.000 ± 0.005 , -39 CHD DIM WAS 1.000 ± 0.005 , -41 CHD DIM WAS 1.000 ± 0.005 , -43 CHD DIM WAS 1.000 ± 0.005 , -45 CHD DIM WAS 1.000 ± 0.005 , -47 CHD DIM WAS 1.000 ± 0.005 , -49 CHD DIM WAS 1.000 ± 0.005 , -51 CHD DIM WAS 1.000 ± 0.005 , -53 CHD DIM WAS 1.000 ± 0.005 , -55 CHD DIM WAS 1.000 ± 0.005 , -57 CHD DIM WAS 1.000 ± 0.005 , -59 CHD DIM WAS 1.000 ± 0.005 , -61 CHD DIM WAS 1.000 ± 0.005 , -63 CHD DIM WAS 1.000 ± 0.005 , -65 CHD DIM WAS 1.000 ± 0.005 , -67 CHD DIM WAS 1.000 ± 0.005 , -69 CHD DIM WAS 1.000 ± 0.005 , -71 CHD DIM WAS 1.000 ± 0.005 , -73 CHD DIM WAS 1.000 ± 0.005 , -75 CHD DIM WAS 1.000 ± 0.005 , -77 CHD DIM WAS 1.000 ± 0.005 , -79 CHD DIM WAS 1.000 ± 0.005 , -81 CHD DIM WAS 1.000 ± 0.005 , -83 CHD DIM WAS 1.000 ± 0.005 , -85 CHD DIM WAS 1.000 ± 0.005 , -87 CHD DIM WAS 1.000 ± 0.005 , -89 CHD DIM WAS 1.000 ± 0.005 , -91 CHD DIM WAS 1.000 ± 0.005 , -93 CHD DIM WAS 1.000 ± 0.005 , -95 CHD DIM WAS 1.000 ± 0.005 , -97 CHD DIM WAS 1.000 ± 0.005 , -99 CHD DIM WAS 1.000 ± 0.005 , -101 CHD DIM WAS 1.000 ± 0.005 , -103 CHD DIM WAS 1.000 ± 0.005 , -105 CHD DIM WAS 1.000 ± 0.005 , -107 CHD DIM WAS 1.000 ± 0.005 , -109 CHD DIM WAS 1.000 ± 0.005 , -111 CHD DIM WAS 1.000 ± 0.005 , -113 CHD DIM WAS 1.000 ± 0.005 , -115 CHD DIM WAS 1.000 ± 0.005 , -117 CHD DIM WAS 1.000 ± 0.005 , -119 CHD DIM WAS 1.000 ± 0.005 , -121 CHD DIM WAS 1.000 ± 0.005 , -123 CHD DIM WAS 1.000 ± 0.005 , -125 CHD DIM WAS 1.000 ± 0.005 , -127 CHD DIM WAS 1.000 ± 0.005 , -129 CHD DIM WAS 1.000 ± 0.005 , -131 CHD DIM WAS 1.000 ± 0.005 , -133 CHD DIM WAS 1.000 ± 0.005 , -135 CHD DIM WAS 1.000 ± 0.005 , -137 CHD DIM WAS 1.000 ± 0.005 , -139 CHD DIM WAS 1.000 ± 0.005 , -141 CHD DIM WAS 1.000 ± 0.005 , -143 CHD DIM WAS 1.000 ± 0.005 , -145 CHD DIM WAS 1.000 ± 0.005 , -147 CHD DIM WAS 1.000 ± 0.005 , -149 CHD DIM WAS 1.000 ± 0.005 , -151 CHD DIM WAS 1.000 ± 0.005 , -153 CHD DIM WAS 1.000 ± 0.005 , -155 CHD DIM WAS 1.000 ± 0.005 , -157 CHD DIM WAS 1.000 ± 0.005 , -159 CHD DIM WAS 1.000 ± 0.005 , -161 CHD DIM WAS 1.000 ± 0.005 , -163 CHD DIM WAS 1.000 ± 0.005 , -165 CHD DIM WAS 1.000 ± 0.005 , -167 CHD DIM WAS 1.000 ± 0.005 , -169 CHD DIM WAS 1.000 ± 0.005 , -171 CHD DIM WAS 1.000 ± 0.005 , -173 CHD DIM WAS 1.000 ± 0.005 , -175 CHD DIM WAS 1.000 ± 0.005 , -177 CHD DIM WAS 1.000 ± 0.005 , -179 CHD DIM WAS 1.000 ± 0.005 , -181 CHD DIM WAS		10/26/16	DPD	JAG
	17-0112		4 CHD DIM WAS $6X \pm 0.375$ THRU ALL, 6.64 ± 0.377 -003, 000 THRU ALL, -20 CHD DIM WAS $2X \pm 0.313$ THRU ALL, 0.25 ± 0.132 THRU ALL, -25 CHD DIM WAS $2X \pm 0.313$ THRU ALL, 0.25 ± 0.132 THRU ALL, -27 CHD B/O INFO WAS $0.21 \times 3/16$ IS $0.14 \times 1/8$ -39 CHD DIM WAS 1.148 ± 0.114 WAS 28.00 IS 28.00 , -48 CHD B/O INFO WAS $0.21 \times 3/16$ IS $0.14 \times 1/8$ -90881A072 IS $92 \times 1/4$ 900801A077 -49 4 -50 CHD DIM WAS PLASTIC IS GREEN POLYESTER.		5/9/2017	RJC	JAG

	
TITLE ENGINE STAND	
DWG NO. RBT18700-101	REV 7
MATL. HEAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° X $\pm$.1 SURFACES $\pm$ 125/10 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER FLATING 3. INTERPRET DIM AND TOL PER ASME Y14.3M-2009 USED ON MODEL R.R. 250-110 TO C47
DRAWN BY: COLE CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	SCALE: 1:8 DATE: 4/2/2009 SHEET 1 OF 28



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043085



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

copy

PO No: PO043085
PO Date: 4/3/19
Due Date: 6/12/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Attention: Walz, Shigi

Via: Ground
Pymt Terms: Net 60

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192701	RBT18700-101P			Engine Stand REV 7	Firmed	-	6/12/19	2 pcs	0 pcs	2 pcs	\$3,500.00/pcs	\$7,000.00
								18 JUN 17 2019					
2	196629	RBT18700-101P			Engine Stand REV 7	Firmed	-	6/26/19	3 pcs	0 pcs	3 pcs	\$3,500.00/pcs	\$10,500.00

Grand Total: \$17,500.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 6/17/19 3:29 PM dart.lussier.patrick



METAL TECHNOLOGY INC.

www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 25448
Shipment Date: 17-Jun-2019
Ship Via: Pick up at METEC
Order Number: 3701
Order Date: 04/03/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: P0043085 ✓
Terms: Net 60 Days

----- Quantity -----								Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>
1	5	2 ✓	3	0	EA	RBT18700-101P Engine Stand	7	3701-01

RECEIVED

JUN 17 2019

DART AEROSPACE LTD.

JUN 17 2019

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
2 ✓	RBT18700-101P ✓	Engine Stand	7	43085 ✓

DAS
61
9-89

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, June 17, 2019